

CLAIMS

What is claimed is:

- 5 1. A crown closure comprising:
 a shell having an inside, a top, a skirt, a curved portion and a plurality of
 serrations which do not project into said curved portion;
 said curved portion disposed between said top and said skirt;
 a liner secured to said inside; and
10 wherein said curved portion is adapted to be the same shape as the mouth
 contour of a bottle.
2. The crown closure of claim 1 wherein said curved portion has a radius
 greater than about 1.7 mm.
- 15 3. The crown closure of claim 1 wherein said curved portion has a radius
 of about 0.157 inches (4 mm).
4. The crown closure of claim 1 wherein said shell is manufactured from
20 a blank having a diameter of about 1.4 inches (35.5 mm).
5. The crown closure of claim 1 wherein said shell is formed from a
 blank having a diameter less than about 1.4446 inches.
- 25 6. The crown closure of claim 1 wherein said shell has twenty serrations.
7. A closed container comprising:
 a bottle having a mouth;
 a crown closure secured over said mouth;
30 said crown closure comprising:
 a shell having an inside, a top, a skirt, a curved portion and a plurality of
 serrations which do not project into said curved portion;
 said curved portion disposed between said top and said skirt;
 a liner secured to said inside; and
35 wherein said curved portion is adapted to be the same shape as the contour of
 said mouth.
8. The closed container of claim 7 wherein said curved portion has a
 radius greater than about 1.7 mm.
- 40 9. The closed container of claim 7 wherein said curved portion has a
 radius of about 0.157 inches (4 mm).
10. The closed container of claim 7 wherein said shell is manufactured
45 from a blank, and said blank has a diameter of about 1.4 inches (35.5 mm).

11. The crown closure of claim 7 wherein said shell is formed from a blank having a diameter less than about 1.4446 inches.

5 12. The closed container of claim 7 wherein said shell has twenty serrations.

13. The closed container of claim 7 wherein:
said bottle mouth includes an upper portion and a lower portion with a fulcrum therebetween; and
10 said curved portion has a radius that is similar to said upper portion.

14. A method of producing crown closures comprising the steps of:
a) providing a die press;
b) providing metal sheets which may be die pressed into crown closures;
15 c) using said die press to form blanks having a diameter of about 1.4 inches (35.5 mm); and
d) using said die press to form crown closures using said blanks.

15. The method of claim 14, wherein:
20 said crown closures include a shell having an inside, a top, a skirt, a curved portion and a plurality of serrations which do not project into said curved portion; and
said curved portion has a radius of about 0.157 inches (4 mm).

25 16. The method of claim 14, wherein:
said crown closures include a shell having an inside, a top, a skirt, a curved portion and a plurality of serrations which do not project into said curved portion; and
said curved portion has a radius greater than about 1.7 mm.

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